

Shop 27/03!

Date: Tuesday, 3/18/2008 3:55:15 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BRACKET		
Job Number	38087			Part Number	D3610041		
Estimate Number	12812			Drawing Number	D3610 REV.A		
P.O. Number				Project Number	N/A		
This Issue	3/18/2008	S.O. No.		Drawing Revision	A		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	3/28/2008	Qty:	10
Previous Run	36085			Um:	Each		
Written By	<i>JL 08/03/18</i>						
Checked & Approved By							
Comment	est rev A new issue 07.03.28 EC est rev B released, changed mat'l EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4140NB1500X15000	AISI 4140 Steel Bar
Comment: Qty.: 0.5775 f(s)/Unit Total : 5.7750 f(s) AISI 4140 Steel Bar		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blank 6.600 " long <i>M106468X5pcs</i> <i>M106674X5pcs</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		
1- Mill as per Folio FA692 Rev: <u>AA</u> & Dwg D3610 Rev: <u>A</u>		
2-Deburr per dwg D3610		

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
<i>J.L 08/03/24</i>		
Comment: SECOND CHECK		
<i>JL 08/03/24</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'SINK AS PER DWG D3610

mf

08.03.25(10)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/25 (x10)

8.0 POWDER COATING

POWDER COATING



M 106 442

(10X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

mf 08/03/26

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gl

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.03.26

(x10)

10.0 MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nutplate

Batch: M 107 275

S 08/03/26

(10)

11.0 MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

RIVET

batch: M 102 401

S 08/03/26

(10)

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet Nut Plate as per Dwg D3610

ml 08/03/26

x10

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/26 (x10)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: BRACKET

Job Number: 38087

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 244A

8/3/26 SQ

10x

(10)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 8/03/27

Job Completion



u 8/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

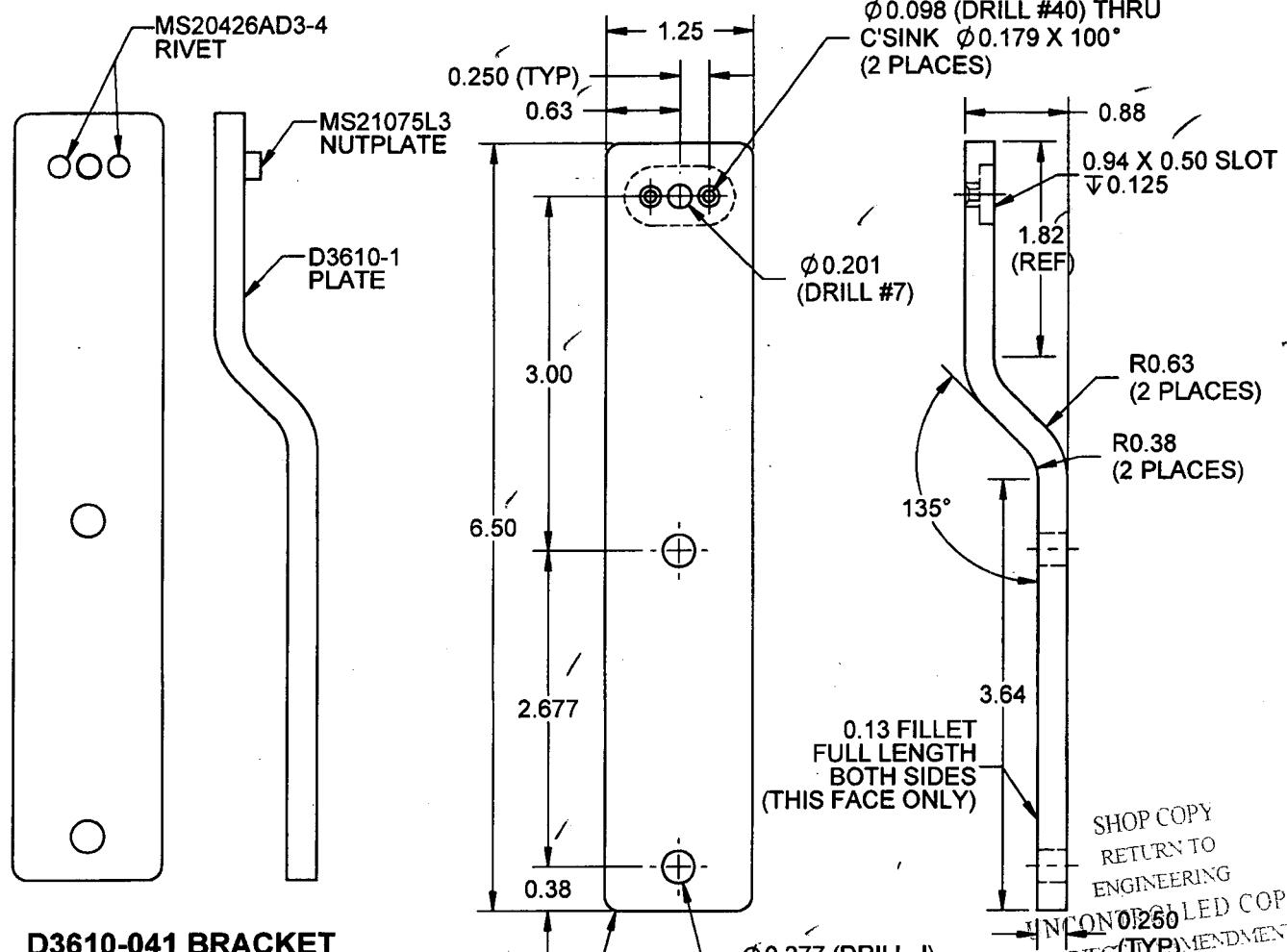
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3610
DATE 07.04.20	TITLE BRACKET	REV. A SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE

**D3610-041 BRACKET**

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

D3610-1 PLATE

IN CON 01250
SUBJEC (TYP)
LED COPY
MENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *38087*

RELEASED07.04.25 *[initials]***D3610-041 NOTES:**

- 1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	38087
Description: bracket	Part Number:	D3610-041
Inspection Dwg: D3610 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

1

First Article

1

Prototype

Measured by:	J.L.
Date:	08/03/23

Audited by:	SA
Date:	08/03/24

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	